

Date: Thursday, 3/30/2006 8:31:07 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FUEL PURGE CANISTER	
<b>Job Number</b> :	26416A			
<b>Estimate Number</b> :	10441			
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D32621	
<b>This Issue</b> :	3/30/2006	<b>Drawing Number</b> :	D3262 REV B	
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A	
<b>First Issue</b> :	N/A	<b>Drawing Revision</b> :	B	
<b>Previous Run</b> :	23284A	<b>Material</b> :	N/A	
<b>Written By</b> :	<i>See Comment Below</i>		<b>Due Date</b> :	4/30/2006
<b>Checked &amp; Approved By</b> :	<i>06.03.30</i>		<b>Qty:</b>	4 Um: Each
<b>Comment</b> :	Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM			

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6T5000W125	6061-T6 Tube 5.00X.125W
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**Comment:** Qty.: 0.9406 f(s)/Unit Total : 3.7624 f(s)  
 Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall  
 (M6061T6T5.000W.125)  
 Identify as D3262-1  
 Batch: *M100864*

*SA 06.04.28* *4.*

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW  
 Cut D3262-1 to length as per Dwg D3262  
 Identify as D3262-1

*SA 06.04.28* *4*

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Deburr

*SA 06.04.28* *4*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*SA 06.04.28* *4*

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

*BC 06.05.08* *✓* *4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 3/30/2006 8:31:07 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 26416A

Part Number: D32621

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA19*

*RE. 06.05.16* 4

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/05/17* (4)

Job Completion



*06.05.17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

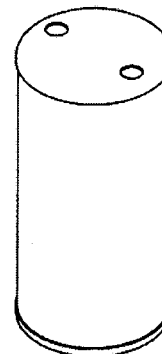
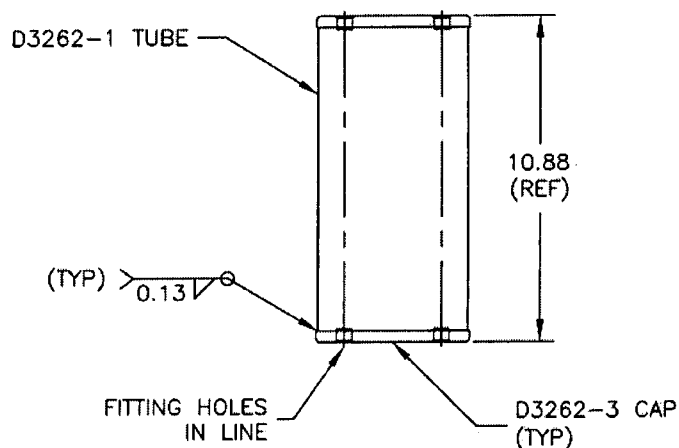
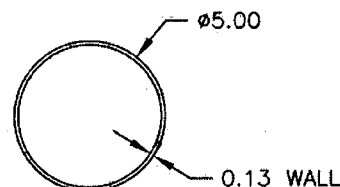
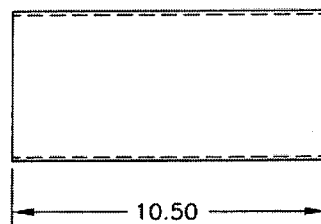
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3262	REV. B SHEET 1 OF 2
DATE 05.02.14		TITLE FUEL PURGE CANISTER	SCALE 1:1
A	04.05.06	NEW ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	

**RELEASED**  
05.02.14**D3262-041 CANISTER ASSEMBLY****1 D3262-1 TUBE****D3262-041:**

1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8)  
TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)

2) WELD PER QSI 004.

3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psig AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3 SUBJECT TO AMENDMENT

5) BREAK ALL SHARP EDGES 0.005 TO 0.010

6) ALL DIMENSIONS ARE IN INCHES

7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER NO. 26416A

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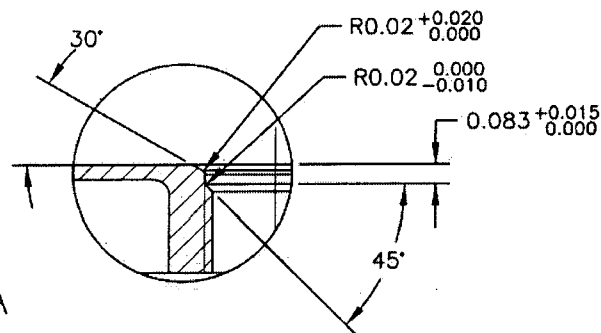
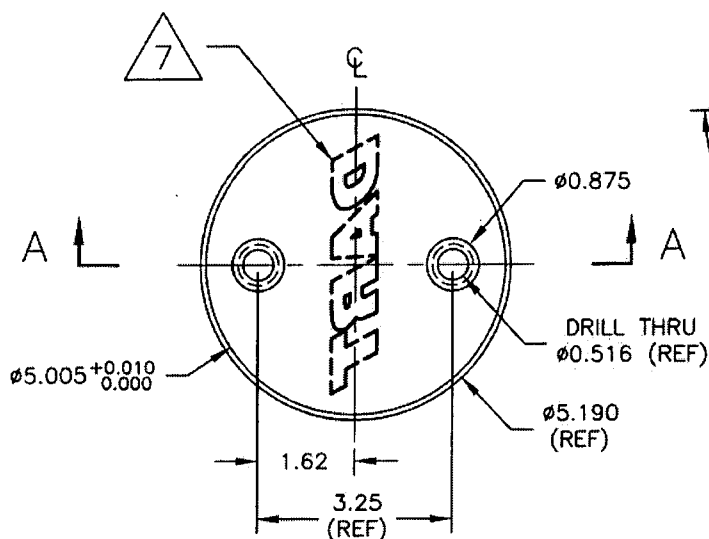
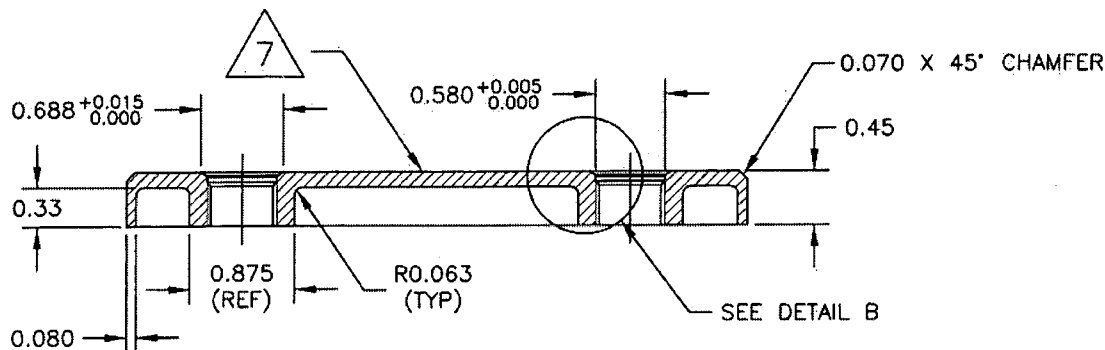
WORK ORDER

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**DART**

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3262	REV. B SHEET 2 OF 2
DATE 05.02.14		TITLE FUEL PURGE CANISTER	SCALE 1:3

**D3262-3 CAP****RELEASED**  
05.02.14**D3262-3**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR  
(REF. DART SPEC. M6061T6B)
- 2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH X 0.010 DEEP  
(MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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NO. 26416A

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DART SPACE LTD

Work Order:

26416A

Part Name:

Part Number:

D3262-1

Inspector:

Rev:

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

☐

First Article

☐

Prototype

Dimension  
Location

10.50

Tolerance

±.030

Actual  
Dimension

10.50

Accept

/

Reject

Method of  
Inspection

Comments

Measured by:

SA

Audited by:

TGA

Prototype Approval:

N/A

Date:

06.05.08

Date:

06.05.08

Date:

N/A

Rev:

Date:

Change

New Issue

Revised by  
KJ/RF

Approved